

### ABSTRACT OF THE DISCLOSURE

A method of driving on a movable piece material over a drive-on path, comprising the steps of providing a drive-on position of the piece material inside a drive-on region, computing control data sets preliminarily in a first computation step, providing in the control data set a travel set which describes the drive-on path at the drive-on position, starting the first computation step for the travel set from a fixed drive-on position of the piece material, optimizing the travel set to the first fixed position of the piece material with respect to the drive-on speed, determining, directly before a start of a drive-on movement in accordance with the travel set, an actual drive-on position of the piece material, performing a second computation step which a corresponding actual travel set changed depending on the determined actual drive-on position of the piece material so that the drive-on path is changed in direction of the actual drive-on position, and performing a drive-on movement by working off of the travel set determined in the second computation step.